

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127681***127681***

Page 2

Item ID: 646.9701

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cutter Sub Assembly

Start Date: 12/17/14 Start Qty: 3.00

3

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: **BMF**

0.00

140

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER IAW MPP-120

3DAS
CS
9-69

FEB 18 2015

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

15/2/18**MS-18**

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Picklist Print

December-17-14 1:49:55 PM

Page 1

Work Order ID: 127681

127681

Parent Item: 646.9701

646 9701

Parent Item Name: Cutter Sub Assembly

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9710 *646 9710* Body		Manufactured	No			110	Each	21.0000	1	3	DAS 41 9-89	15-2-13	

Location	Loc Qty	Loc Code
MF	21	
106354	3	
94495	3	
98917	2	
98918	13	

646.9711 *646 9711* Blade		Manufactured	No			110	Each	20.0000	2	6	DAS 41 9-89	15-2-13	
--	--	--------------	----	--	--	-----	------	---------	---	---	-------------------	---------	--

Location	Loc Qty	Loc Code
MF	20	
109731	1	
98911	19	

MS21042L08 *MS21042L 08* Nut		Purchased	No			110	Each	1,295.000	6	18	DAS 41 9-89	15-2-13	
---	--	-----------	----	--	--	-----	------	-----------	---	----	-------------------	---------	--

Location	Loc Qty	Loc Code
CA	101	
m129682	101	
ST304	1194	
123900	16	
m128401	578	
m130325	600	

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FAULT CATEGORY

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Picklist Print

December-17-14 1:49:55 PM

Page 2

Work Order ID: 127681

127681

Parent Item: 646.9701

646.9701

Parent Item Name: Cutter Sub Assembly

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 3.00

Required Qty: 3.00

MS27039-08-19

Purchased

No

110

Each

486.0000

6

18

DAS

41

9-89

15-2-13

MS27039-08-19

Screw

131264

Location

Loc Qty

Loc Code

18

ST273A

486

m130505

486

NAS1149FN832P

Purchased

No

110

Each

6,096.000

12

36

DAS

41

9-89

15-2-13

NAS1149FN832P

Washer

Location

Loc Qty

Loc Code

ST260a

3600

125268

3600

st268

2496

123185

30

M130388

2466

36

DQA: _____ Date: _____



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APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04559

SHEET 1 OF 1

DWG NO. 646.9700

REV: C

PREPARED BY

D. MEJIA

DATE: 06/11/2014

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR

[Signature]

MFG

[Signature]

QC

[Signature]

EFF.

NEXT ORDER

TRANSACTION CODES (TC):

A-ADD
R-REVISE

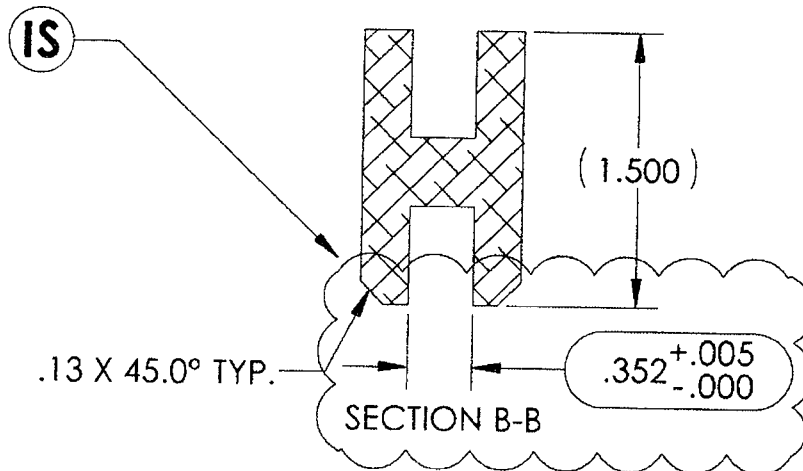
C-CREATE
D-DELETE

REASON: ADDED DIMENSION AND TOLERANCE

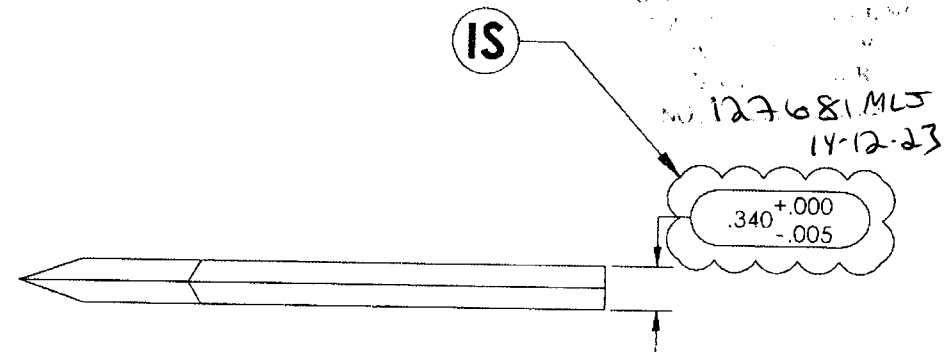
ECR:

D-14-05

SHEET 2, ZONE D7 IS:



SHEET 5, ZONE B5 IS:



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

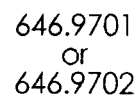
CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVE
	LAST PROPOSED REVISION PRO		NAC
	INITIAL RELEASE	05/29/99	P. BRAVO
A	BIC INCORPORATED ECH 02746 03036, 1/912	06/07/13	P. BRAVO
B	BIC INCORPORATED ECH 02767	07/03/13	P. BRAVO
C	BIC INCORPORATED ECH 04039	06/09/13	P. BRAVO



① MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12

② FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX

③ MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS

④ FINISH: PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX

5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED

6. IDENTIFY IAW MPP-120

⑦ APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY

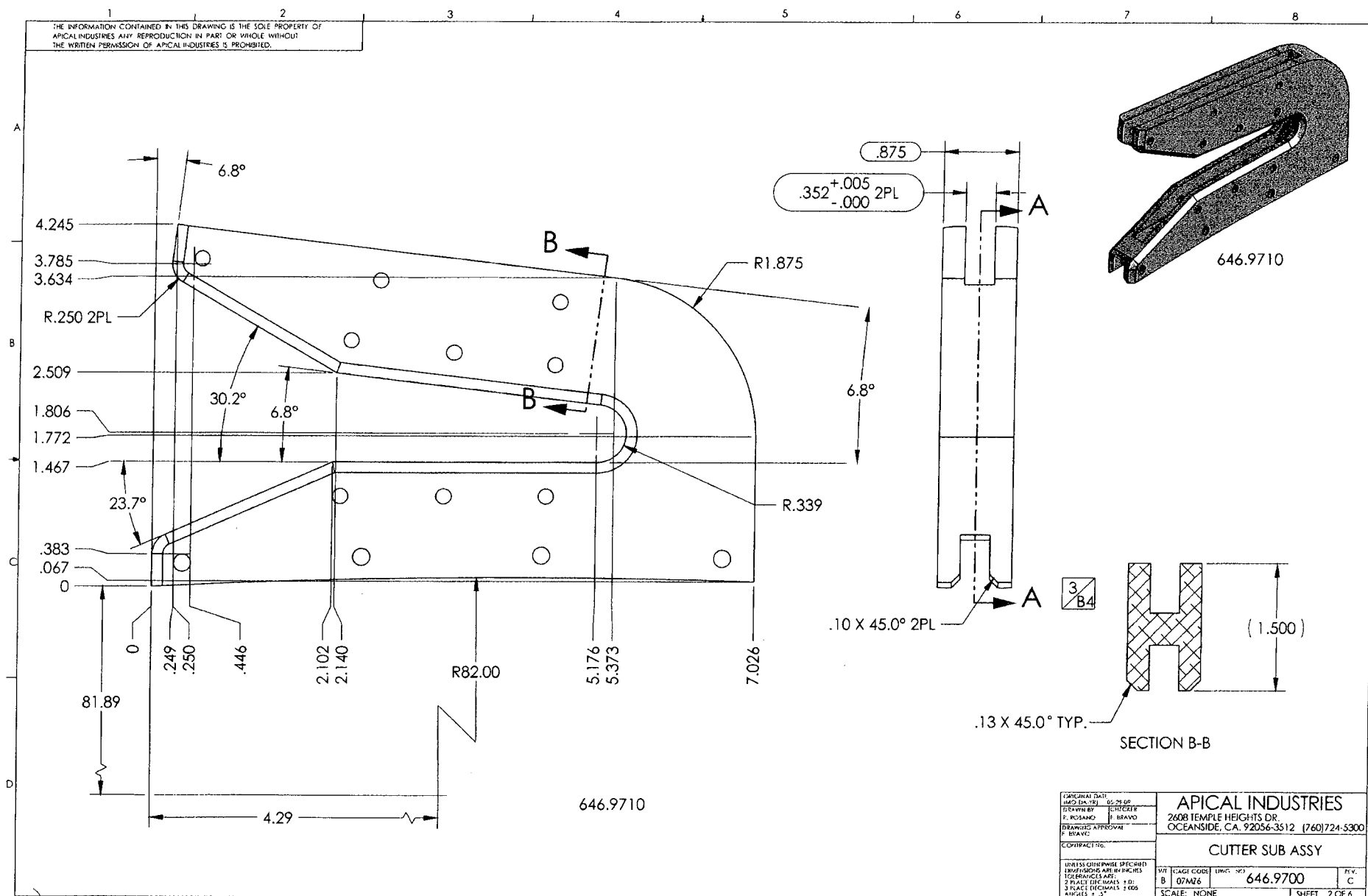
⑧ CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE

⑨ ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

04550

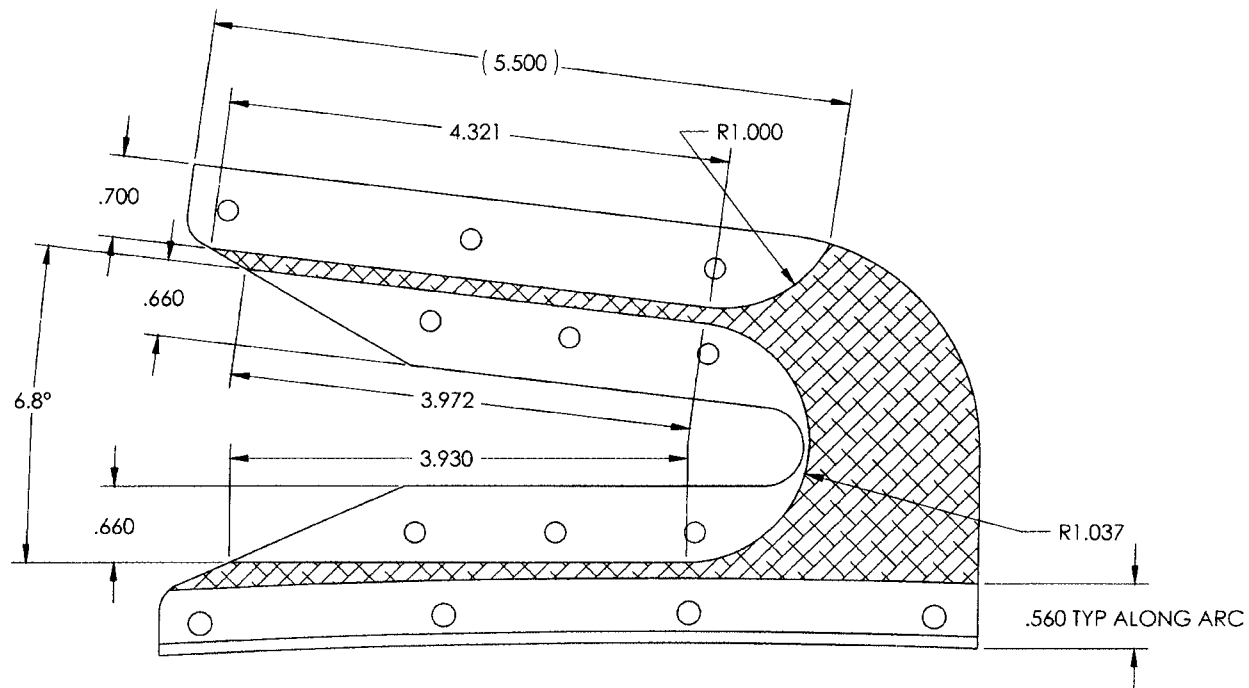
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ORIGINAL DATE: 02-26-88		APICAL INDUSTRIES	
DRAWN BY: E. ROSANO	ENGINEER: J. BRAVO	2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL: J. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO:		CUTTER SUB ASSY	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES			
TOLERANCES ARE:			
2 PLACES DECIMALS ± .01			
3 PLACES DECIMALS ± .005			
ANGLES ± .5°			
VT	DATE CODE	TIME	REV.
B	07M26		C
SCALE: NONE		SHEET 2 OF 6	

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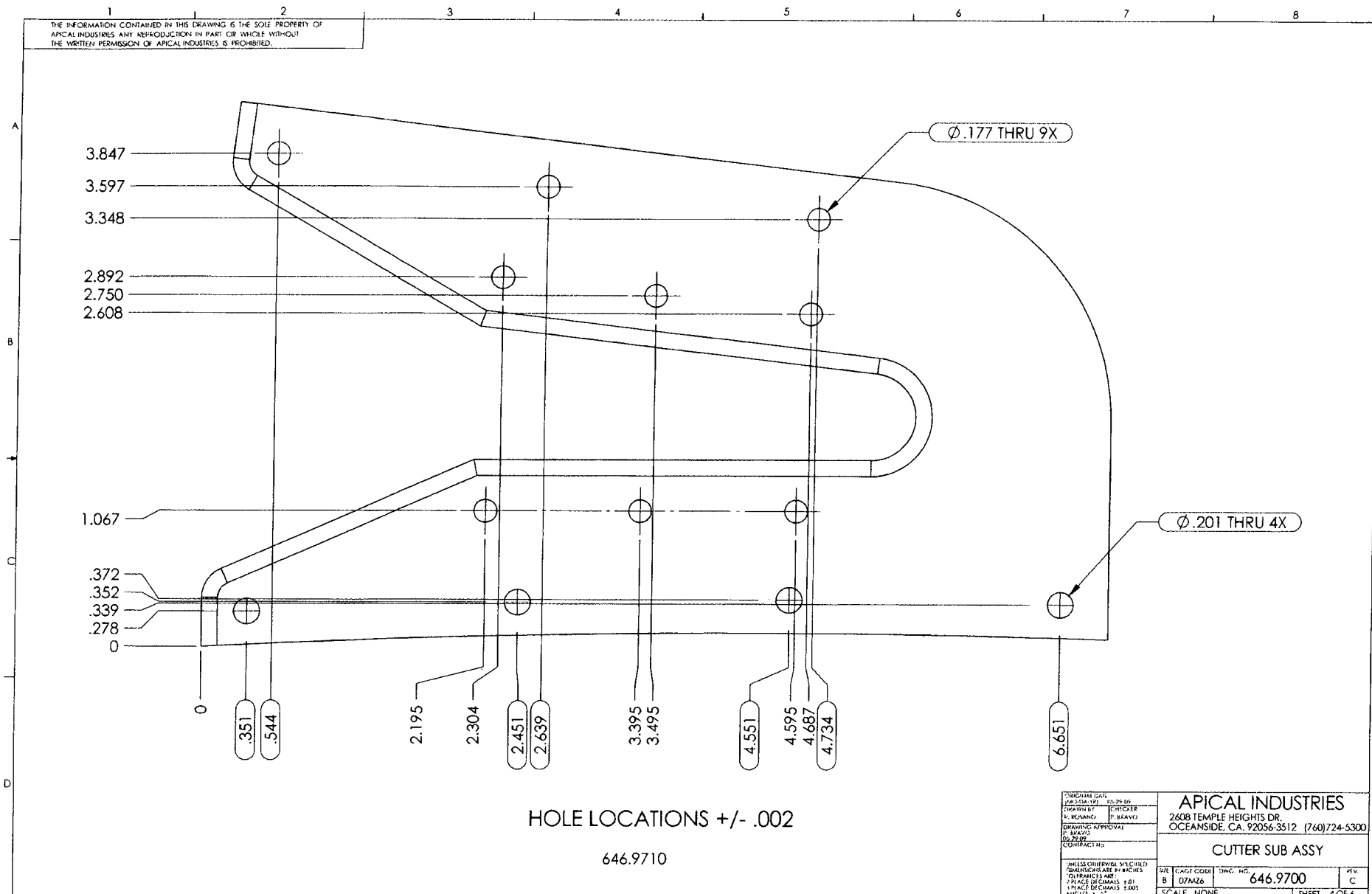


SECTION A-A $\frac{2}{C6}$

646.9710

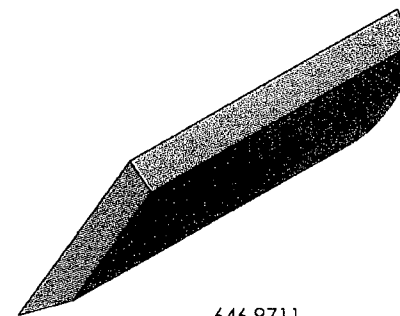
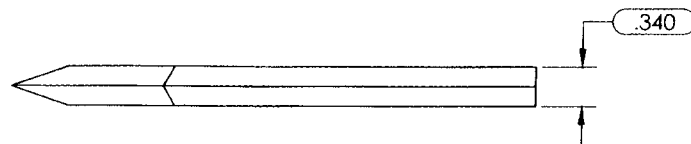
ORIGINAL DATE REV. DATE REV. BY REV. BY REV. BY REV. BY REV. BY REV. BY		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CUTTER SUB ASSY		REV. C	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		REV. B	646.9700
SCALE NONE		SHEET 3 OF 6	

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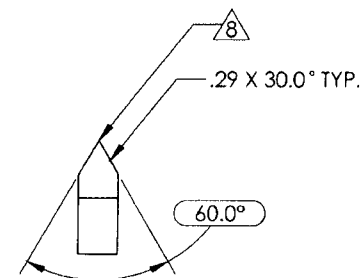
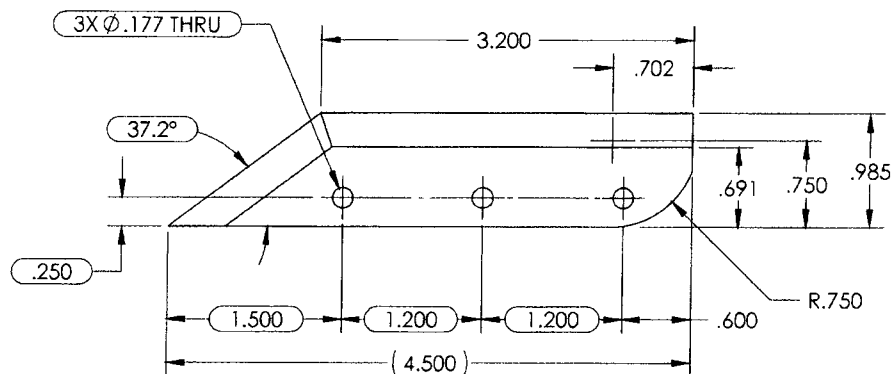


ORIGINAL DATE (MM-DD-YY) DRAWN BY (K. BEAUMONT) CHECKED BY (P. BEAUMONT) DRAWING APPROVAL (S. BEAUMONT) CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET CODE B 07M26	DWG. NO. 646.9700
SCALE NONE		SHEET 4 OF 6	

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646.9711



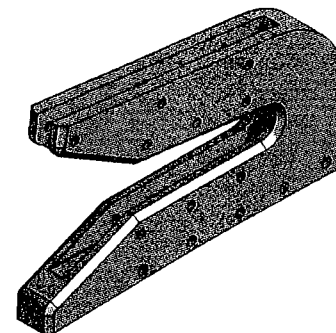
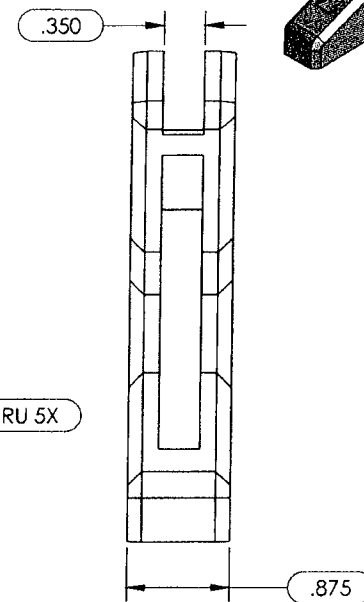
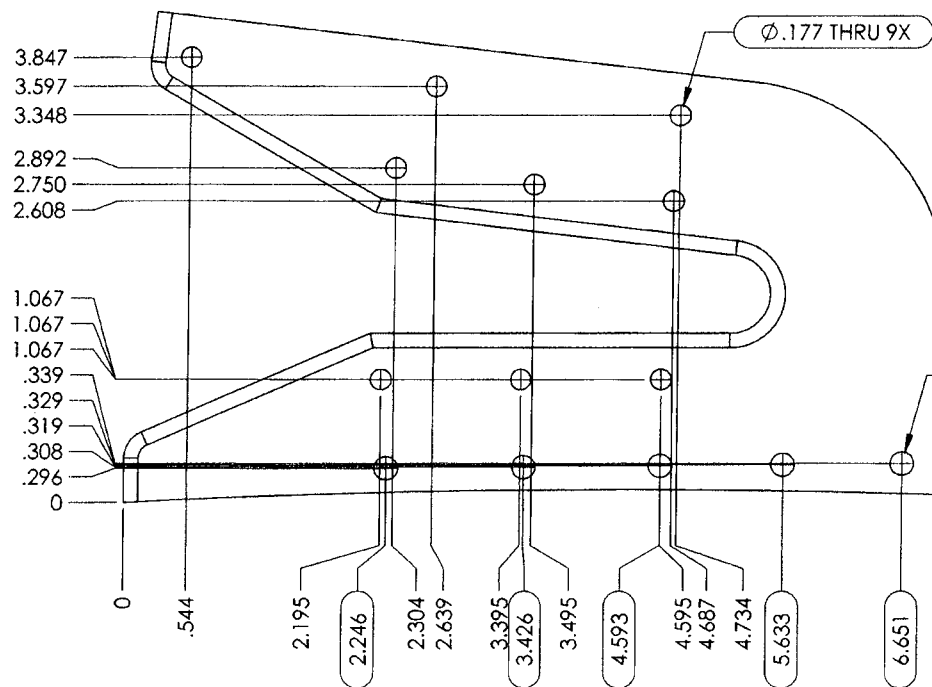
646.9711

ORIGINAL DATE 1982-04-15		DESIGNED BY E. J. SAHAG	
REWORKED BY K. P. SAHAG		CHECKED BY P. BRANCO	
DRAWING APPROVAL P. BRANCO		CONTRACT NO. 646.9711	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		DWG NO. 8 07M46	UNIT NO. 646.9700
SCALE NONE		REV C	
		SHEET 5 OF 6	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

CUTTER SUB ASSY

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646.9712 $\triangle 9$

646.9712

ORIGINAL DATE 05-29-09 DRAWN BY: E. RUSANO CHECKED BY: P. BRAYO DRAWING APPROVAL: P. BRAYO 05-29-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
GEOMETRIC FIN:		CUTTER SUB ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACES DECIMALS ±.03 3 PLACES DECIMALS ±.010 ANGLES ±.5°		QTY: 1 CAGE CODE: B D7M26	GWD. NO.: 646.9700 REV: C
SCALE: NONE		SHEET: 6 OF 6	